



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

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D206-667-103TRN
Job Sheet 202587



Part No: D206-667-103TRN

Job Qty: 1 pcs

Part Name: Crosstube Turning Detail



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/30/19

Job Tracking No:

Due Date: 11/13/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: ~~DWG REV C~~ IPP Rev:A 08-03-06 new issue DD verified by:ec IPP Rev B 08.04.02 removed polish EC verified by DD

Ship Via:

DWG Rev D

DAS
35
9-89

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	DAS Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
100	Mori Seiki TL-40 - 1	1 pcs		11/13/19	1.00	2.10	Mori Seiki TL-40 - 1			DAS 66 2019/11/1 9-89
110	QC 2	1 pcs		11/13/19	0.00	0.00	QC 2 - 1			
							QC 2 - 12			
							QC 2 - 14			
							QC 2 - 17			
							QC 2 - 19			
							QC 2 - 2			
							QC 2 - 20			
							QC 2 - 22			
							QC 2 - 23			
							QC 2 - 25			
							QC 2 - 32			
							QC 2 - 33			
							QC 2 - 35			
							QC 2 - 39			
							QC 2 - 4			
							QC 2 - 40			
							QC 2 - 44			
							QC 2 - 45			
							QC 2 - 48			
							QC 2 - 49			
							QC 2 - 50			
							QC 2 - 51			
							QC 2 - 52			
							QC 2 - 57			
							QC 2 - 62			
							QC 2 - 63			
							QC 2 - 8			
							QC 2 - 66			DAS 66 2019/11/1 9-89
							QC 2 - 64			

					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
120	Mori Seiki TL-40 - 1 - B4B	1 pcs	11/13/19	1.00 2.10	Mori Seiki TL-40 - 1 - B4B	DAS 66 2019/11/04 9-89
130	QC 2	1 pcs	11/13/19	0.00 0.00	QC 2 - 1	
					QC 2 - 12	
					QC 2 - 14	
					QC 2 - 17	
					QC 2 - 19	
					QC 2 - 2	
					QC 2 - 20	
					QC 2 - 22	
					QC 2 - 23	
					QC 2 - 25	
					QC 2 - 32	
					QC 2 - 33	
					QC 2 - 35	
					QC 2 - 39	
					QC 2 - 4	
					QC 2 - 40	
					QC 2 - 44	
					QC 2 - 45	
					QC 2 - 48	
					QC 2 - 49	
					QC 2 - 50	
					QC 2 - 51	
					QC 2 - 52	
					QC 2 - 57	
					QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	DAS 66 2019/11/04 9-89
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
140	QC 8	1 pcs	11/13/19	0.00 0.00	QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	

					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
					QC 8 - 61	
						DAS 76 9-89
145 Crosstubes - 2 - B4B	1 pcs	11/13/19	0.00 0.59	Crosstubes - 1 - B4B		
				Crosstubes - 2 - B4B		
				Crosstubes - 3 - B4B		
				Crosstubes - 4 - B4B		
150 Handfinish - 1-1 Chemical-B4B	1 pcs	11/13/19	0.00 1.00	Handfinish - 1 - 1 - B4B		
				Handfinish - 1 - 2 - B4B		
				Handfinish - 1 - 3 - B4B		
				Handfinish - 1 - 4 - B4B		
				Handfinish - 1 - 5 - B4B		
				Handfinish - 1 - 6 - B4B		
				Handfinish - 1 - 7 - B4B		
				Handfinish - 1 - 8 - B4B		
				Handfinish - 1 - 9 - B4B		
				Handfinish - 1 - 10 - B4B		
				Handfinish - 1 - 11 - B4B		
				Handfinish - 1 - 12 - B4B		
				Handfinish - 1 - 13 - B4B		
				Handfinish - 1 - 14 - B4B		
				Handfinish - 1 - 15 - B4B		
				Handfinish - 1 - 16 - B4B		
				Handfinish - 1 - 17 - B4B		
				Handfinish - 1 - 18 - B4B		
				Handfinish - 1 - 19 - B4B		
				Handfinish - 1 - 20 - B4B		
				Handfinish - 1 - 21 - B4B		
				Handfinish - 1 - 22 - B4B		
160 QC 7	1 pcs	11/13/19	0.00 0.00	QC 7 - 10		
				QC 7 - 13		
				QC 7 - 14		
				QC 7 - 15		
				QC 7 - 17		
				QC 7 - 18		
				QC 7 - 19		
				QC 7 - 2		
				QC 7 - 28		
				QC 7 - 3		
				QC 7 - 30		
				QC 7 - 34		
				QC 7 - 36		

DAS
76
9-89

BB 11/29/2019

NOV 29 2019

				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
				QC 7 - 61	
				QC 7 - 81	
				QC 7 - 76	
				QC 7 - 79	
					DAS 76 9-86
170	Packaging 3-1 - Stock - B4B	1 pcs	11/13/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
180	QC 21 - SA	1 pcs	11/13/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53
					DAS 21 9-86
					DEC 03 2019

Part Op 100 - Mori Seiki TL-40 (Mori Seiki CNC Lathe Large) 1-Fill tube with sand & install plugs DT8534 on both ends as per

Descriptions: Folio FA087 2-Turn first side as per Folio FA087 3-Blend transition lines only, **do not sand whole tube**: FOLIO REV: 2 DWG REV: 2 *Use mill bastard file, brush file repeatedly with file card. *Do not use sandpaper coarser than 320 grit.

110 - QC2-1 (QC2- Inspect parts off machine FAI/FAIB) QC2- Inspect parts off machine FAI/FAIB

120 - Mori Seiki TL-40 (Mori Seiki CNC Lathe Large) 1-Turn second side as per Folio FA087 2-File down transition lines smooth. 3-Blend transition lines only, **do not sand whole tube**: *Use mill bastard file, brush file repeatedly with file card. FOLIO REV: 2 DWG REV: 2 *Do not use sandpaper coarser than 320 grit.

130 - QC2-1 (QC2- Inspect parts off machine FAI/FAIB) QC2- Inspect parts off machine FAI/FAIB

140 - QC8 (QC8- Inspect parts - second check) QC8- Inspect parts - second check

145 - Crosstubes-1 (Crosstubes) GRIND ONLY TRANSITION LINES SMOOTH LONGITUDE WAY.

150 - Crosstubes-3 (Crosstubes) 1- PRESSURE WASH X-TUBE INSIDE AND OUT 2- ALODINE AND ACID ETCH X-TUBE INSIDE AND OUT. USE RED SCOTCH BRITE

160 - QC7-1 (QC7-Inspect Chemical Conversion Coat) QC7-Inspect Chemical Conversion Coat

170 - Identify and stock in kanban rack Location: _____

180 - QC21 (QC21- Final Inspection - Work Order Release) QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6002-115	Crosstube Material	1 pcs (1 ea)	100-Mori Seiki TL-40 - 1	F123961

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Mori Seiki TL-40 - 1	D6002-115	1	64	0

Part Specifications

Specifications could not be found.

Plex 10/30/19 1:39 PM Dart.lajeunesse.marie

DART
AEROSPACE

Container No: S228913



Part: D206-667-103TRN

Job No: 202587

Serial No/Batch: S228913

Revision: D

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K84 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 11/01/19

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DART AEROSPACE LTD		Work Order: 202587
Description: Crosstube Assembly (206L High Fwd)		Part Number: D206-667-143
Inspection Dwg: D206-667-143 Rev: 4 DAS 35 9-89		Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

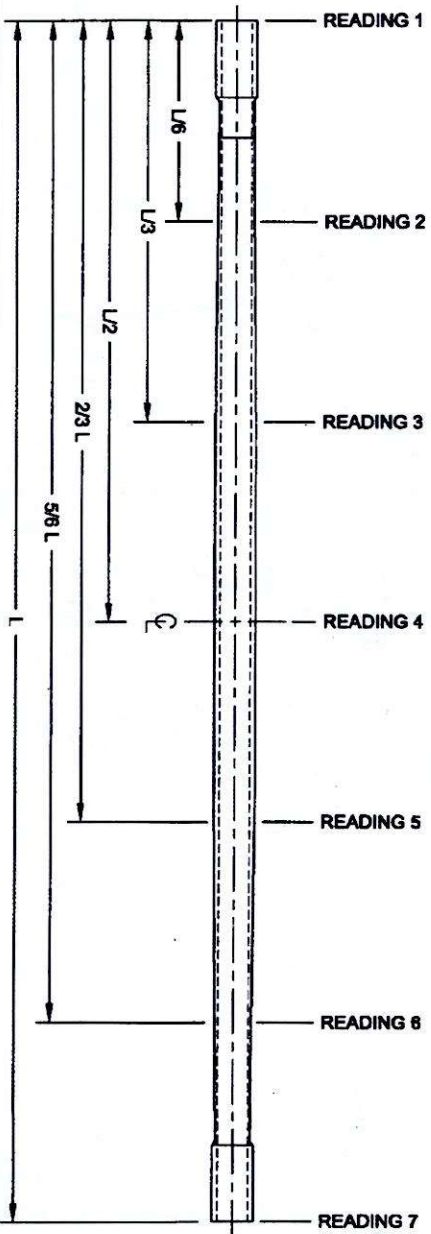
	Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.240	+0.005/-0.000	2.242	✓		CNC-04	
	1.982	+0.005/-0.000	1.987	✓		CNC-08	
	2.019	+0.005/-0.000	2.024	✓		CNC-04	
	2.058	+0.005/-0.000	2.063	✓		↓	
	2.097	+0.005/-0.000	2.102	✓			
	2.136	+0.005/-0.000	2.141	✓			
	2.176	+0.005/-0.000	2.181	✓			
	2.201	+0.005/-0.000	2.206	✓			
	0.125	+/-0.010	.130	✓		CNC-08	
	0.400 x 30°	+/-0.010	.400	✓		"	
	R0.063	+/-0.010	.063	✓		AG	
	R0.500	+/-0.010	.500	✓		"	
	4.438	+/-0.030	4.445	✓		CNC-08	
SIDE B	104.98	+/-0.020	104.990	✓		Tape	
	2.240	+0.005/-0.000	2.242	✓		CNC-04	
	1.982	+0.005/-0.000	1.987	✓		CNC-08	
	2.019	+0.005/-0.000	2.024	✓		CNC-04	
	2.058	+0.005/-0.000	2.063	✓		↓	
	2.097	+0.005/-0.000	2.101	✓			
	2.136	+0.005/-0.000	2.138	✓			
	2.176	+0.005/-0.000	2.181	✓			
	2.201	+0.005/-0.000	2.206	✓			
	0.125	+/-0.010	.128	✓		CNC-08	
	0.400 x 30°	+/-0.010	.400	✓		"	
	R0.063	+/-0.010	.063	✓		AG	
	R0.500	+/-0.010	.500	✓		"	
	4.438	+/-0.030	4.439	✓		CNC-08	

DART AEROSPACE LTD **Work Order:** 202587

Description: Crosstube Assembly (206L High Fwd) **Part Number:** D206-667-143

Inspection Dwg: D206-667-143 **Rev:** 4D **Page 2 of 2**

WALL THICKNESS MEASUREMENT



Location	WALL THICKNESS MEASUREMENT (IN)				Deviation Δw (max-min)	TOLERANCE
	w1	w2	w3	w4		
READING 1 L=0"	.258	.286	.253	.242	.044	0.035"
READING 2 L=17.497	.180	.178	.171	.159	.021	
READING 3 L=34.995	.255	.259	.253	.253	.006	
READING 4 L=52.492	.258	.274	.266	.253	.021	
READING 5 L=69.989	.257	.268	.266	.244	.024	
READING 6 L=87.487	.171	.190	.173	.168	.022	
READING 7 L=104.984	.263	.275	.265	.247	.028	

avg L
0.245 - 0.003

Acceptable per Rev. D
Actual Block Thickness: 100-300
Sitscan 250 Measured Thickness: 100-300

Calibration Result

Measured by: 66 **Audited by:** 76 **Preliminary Approval:**

Date: 20/6/11/04 **Date:** 9-89 **Date:**

Rev	Date	Change	Revised by	Approved
A	04.05.06	New Issue	KJ/RF	
B	06.03.09	Dwg Rev updated	KJ/JLM	
C	10.09.13	Dwg Rev updated	KJ	
D	12.06.04	Wall thickness form added	KJ	

Item	Qty -143	Part Number	Description
1	X	D206-667-143	CROSSTUBE ASSEMBLY (206L HIGH FWD)
2	1	D6002-115	CROSSTUBE
3	2	D2873-043	NUT PLATE
4	2	D2873-045	NUT PLATE
5	2	D2891-1	SUPPORT
6	4	D3595-063-395	RUBBER CUSHION
7	4	MS21920-20	CLAMP (OR MS21920-21)
8	14	MS20601AD4W8	RIVET (OR NAS9302B-4-8)
9	A/R	PROSEAL 890 B-2	SEALANT, AMS-S-8802 CLASS B-2
10	2	AN742D36	CLAMP
11	2	MS9165-05	ANGLE BRACKET
12	2	MS21042L3	NUT (OR MS21042-3)
13	2	MS27039-1-08	SCREW
14	4	NAS1149C0332R	WASHER (OR AN960C10L)

GENERAL NOTES:

- MATERIAL: MANUFACTURED FROM D6002-115
FINISHED LENGTH = 104.98±0.020
- FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- UNITS: INCHES UNLESS OTHERWISE NOTED.
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-143" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- WEIGHT: 15.5 lbs
- PART IS SYMMETRIC ABOUT CENTERLINE.
- RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- BEND PROGRESSIVELY WITH A MINIMUM OF 10 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 8% BASED ON O.D.
- LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- TO INSTALL D2891-1 SUPPORT: ABRASE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.04" TO 0.07" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.
- INSTALL MS21920-20 CLAMPS (OR -21) WITH D3595-063-395 RUBBER CUSHIONS TO SECURE THE D2891-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS ARE LOCATED ON CROSSTUBE SUPPORTS.
- EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.
- MASK AREA UNDER CLAMP PRIOR TO PAINTING.
- SEAL EDGES WHERE AN742D36 CLAMP MEETS WITH THE CROSSTUBE USING SIKAFLEX-241/-291 OR MIL-S-8802 CLASS B2 OR PROSEAL 890 SEALANT.
- PERFORM RESISTANCE CHECK TO ENSURE MAX RESISTANCE IS 10 MEGOHMS.

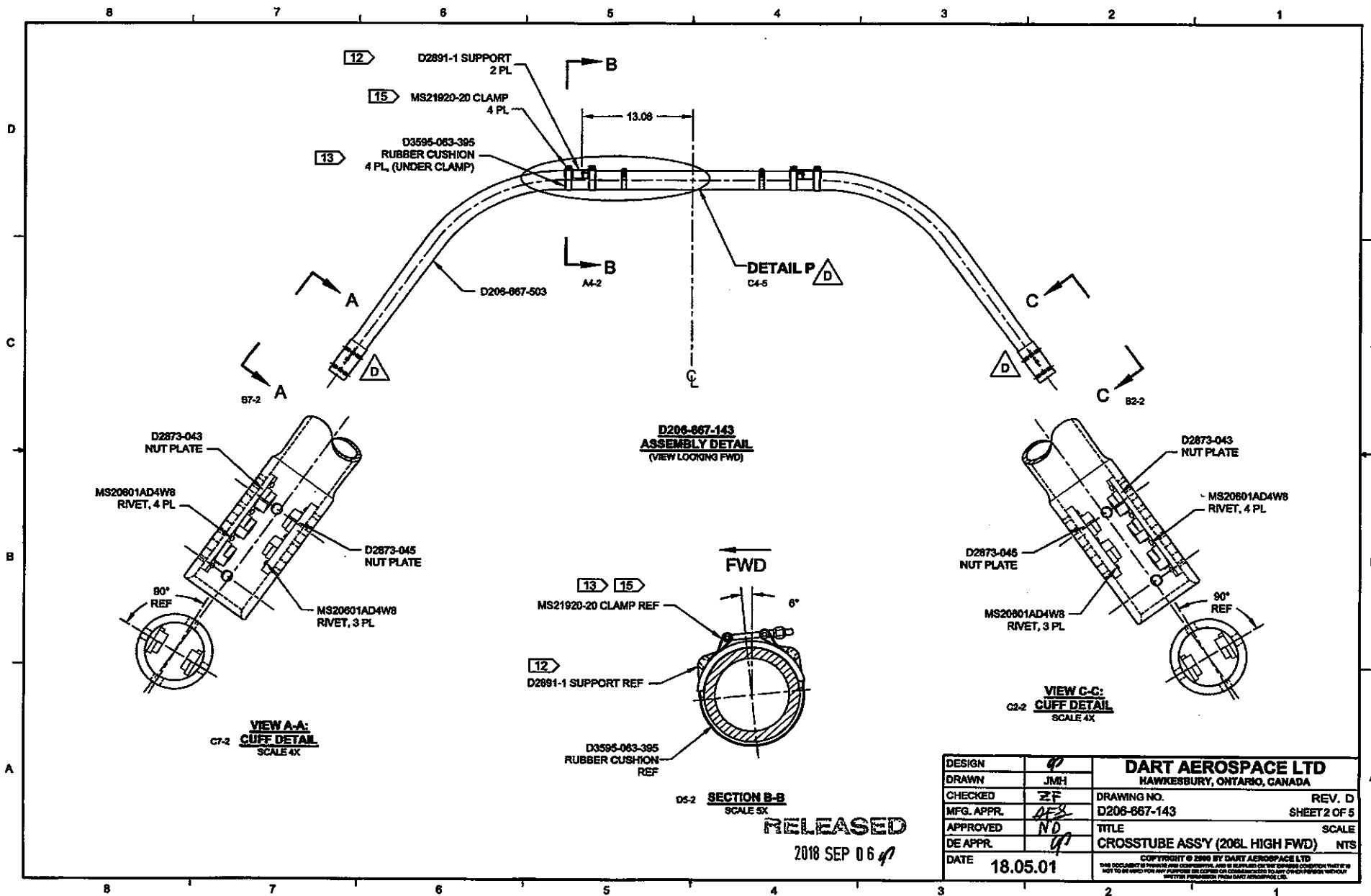
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RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 202587 M/L

19-10-30

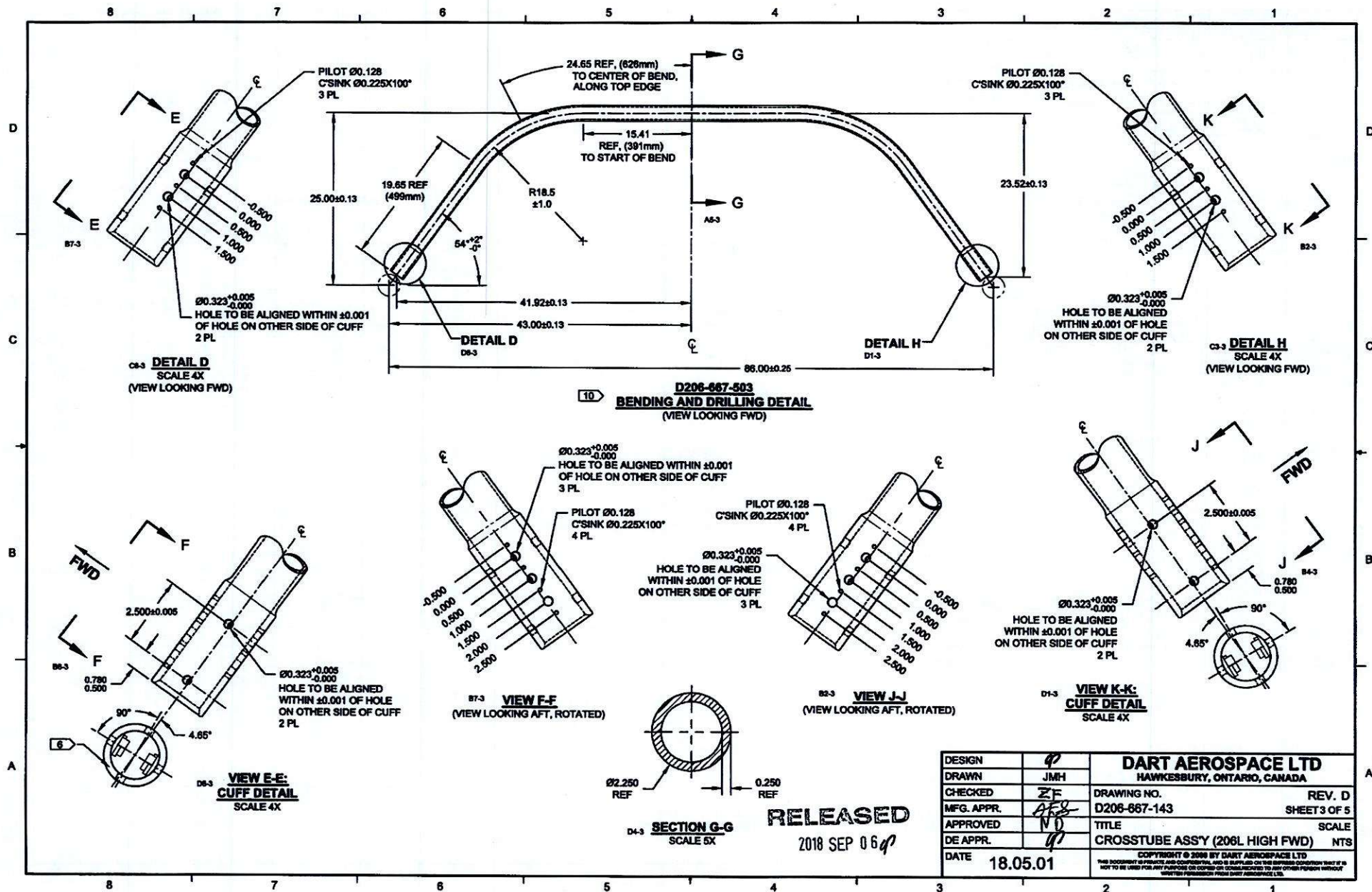
D	REVISE SHEET 2 ASSEMBLY DETAIL HOLE PATTERN PER CAR18-221. UPDATE PARTS LIST AND GENERAL NOTES 12 & 15 TO INCORPORATE DEO C-1. ADD ITEMS 10-14 TO PARTS LIST, ADD GENERAL NOTES 16-18 AND ADD SHEET 5 TO INCORPORATE DEO C-2.	JMH	18.05.01
C	REVISE GENERAL NOTES/PART LIST (ZN D7-1); REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS. D3595-063-395 WAS D2891-400-894 (ZN D6-2 & A5-2); REMOVED REF. & ADD TOLERANCE (ZN D3-3, C4-3, C5-3); RELOCATED FLAG #8 (ZN A8-3) PER NCR 210; MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4.	RF	08.11.06
B	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHTAA SKUDTUBES	PH	05.07.26
A	NEW ISSUE	CP	00.11.17
REV.	DESCRIPTION	BY	DATE
DESIGN	JMH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JMH		
CHECKED	EF	DRAWING NO.	REV. D
MFG. APPR.	AFB	D206-667-143	SHEET 1 OF 5
APPROVED	N/D	TITLE	SCALE
DE APPR.	JMH	CROSSTUBE ASS'Y (206L HIGH FWD)	NTS
DATE	18.05.01	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRELIMINARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR ANY REASON OR IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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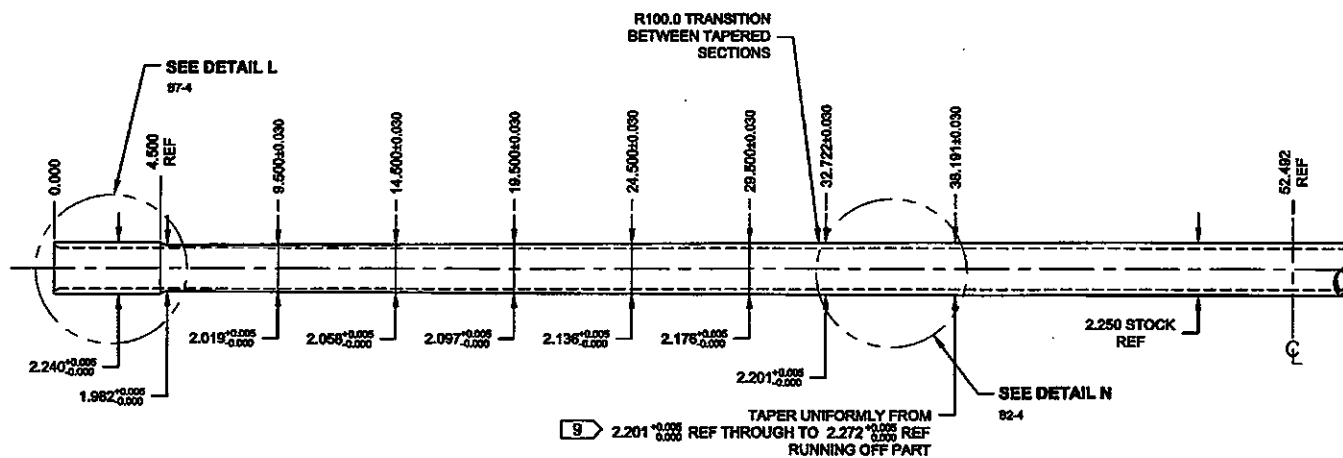
2018 SEP 06
EN 14-717



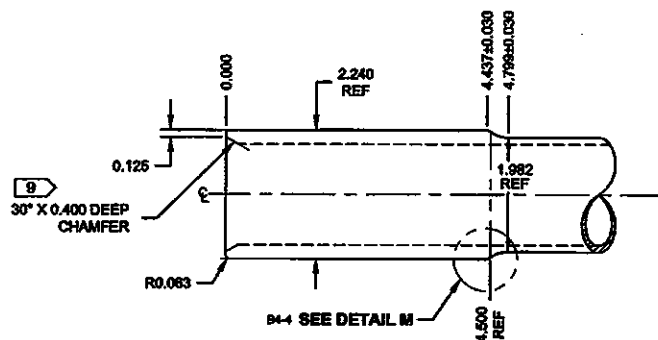
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DRAWN	JME	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ZF	DRAWING NO.	REV. D
MFG. APPR.	DEF	D206-867-143	SHEET 2 OF 5
APPROVED	ND	TITLE	SCALE
DE APPR.	40	CROSSTUBE ASS'Y (206L HIGH FWD) NTS	
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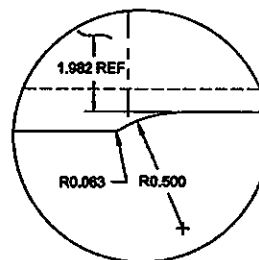
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DRAWN	JMH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ZF	DRAWING NO.	REV. D
MFG. APPR.	AFB	D206-667-143	SHEET 3 OF 5
APPROVED	ND	TITLE	SCALE
DE APPR.	4P	CROSSTUBE ASSY (206L HIGH FWD)	NTS
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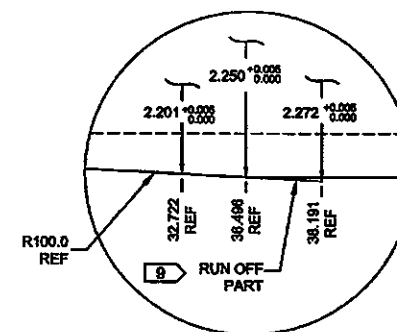
TURNING DETAIL



DETAIL L:
CROSSTUBE CUFF
NOT TO SCALE



DETAIL M:
CUFF TRANSITION
NOT TO SCALE

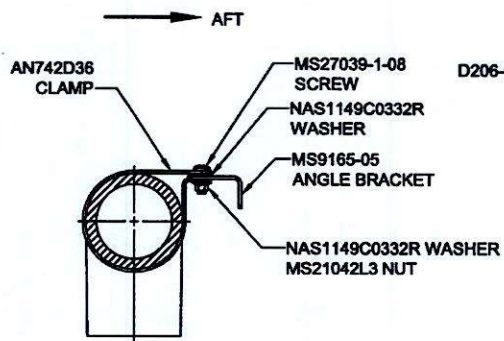


DETAIL N:
TAPER RUN-OFF
NOT TO SCALE

RELEASED

2018 SEP 06

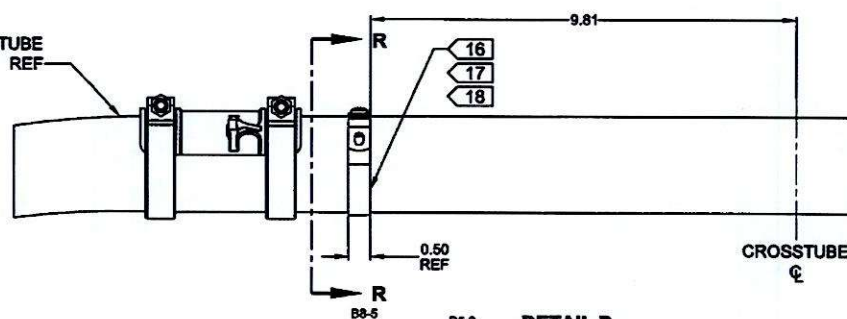
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DRAWN	JMH		
CHECKED	ZF	DRAWING NO.	REV. D
MFG. APPR.	DEF	D208-887-143	SHEET 4 OF 5
APPROVED	NO	TITLE	SCALE
DE APPR.	97	CROSSTUBE ASSY (208L HIGH FWD)	NTS
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C4-5 **SECTION R-R**



D206-667-503 CROSSTUBE
REF



DETAIL P
BONDING STRAP INSTALLATION 2 PL



RELEASED
2018 SEP 06 *qp*

DESIGN	<i>qp</i>	DART AEROSPACE LTD	
DRAWN	JMH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>ZF</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>df</i>	D206-667-143	SHEET 5 OF 5
APPROVED	<i>ND</i>	TITLE	SCALE
DE APPR.	<i>qp</i>	CROSSTUBE ASSY (206L HIGH FWD)	NTS
DATE	18.05.01	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By _____ Lead hand / Supervisor _____ QC / QA Coordinator _____	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
		Other/Details:			